 CARLO GAVAZZI SPACE SpA		AMS02-TCS		1 Doc.N°: NCR-TCS-CGS-C-013 N C R Rev.: 1 Date: 08/09/09 ref Page 1 of 3 attach: 1	
		NON CONFORMANCE REPORT			

2 NCR Title: RAM and WAKE Radiators edges covering					
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IDENTIFICATION	3 Supplier AIDC	4 Purchase Order N°. I/008/08/0	5 Model FM	6 Subsystem M & T RADIATORS	7 Procedure/Work Item N°
	8 NC ITEM Identification RAM RADIATOR ASSY WAKE RADIATOR ASSY (AFE for CGS)		9 Drawing N°. Rev. 21-AMS-000.00.00 B 22-AMS-000.00.00 C		10 P.N. / C.I. N° 21-AMS-000.00.00 22-AMS-000.00.00
	11 Serial N° 01 01				
	12 Next Higher Unit Id. N.A.		13 Drawing N°. Rev. N.A.		14 P.N. / C.I. N° N.A.

DESCRIPTION	16 NON CONFORMANCE Detected During: RECEIVING INSP. <input type="checkbox"/> MANUFACT. <input type="checkbox"/> ASSEMBLY/INTEGRATION <input checked="" type="checkbox"/> FINAL INSPECTION <input type="checkbox"/> TEST <input type="checkbox"/> OTHER..... <input type="checkbox"/>				
	17 Initiator, Dept., Date, Signature L. Cremonesi QA 08.09.2009				
	18 Description of NON CONFORMANCE <i>The edge radius of the Main RAM and WAKE Radiators is not in accordance with NSTS 0700 App.7 Table 11.2-11 a (see next page)</i>				19 Requirements violated
	20 INTERNAL NRB Dispositions: <i>The recovery agreed solution is :</i> a) to remove the white paint from the radiator edges b) to clean the surfaces c) to apply the silver tape on the radiator edges. <i>See next page for details</i>				

INTERNAL NRB DISPOSITIONS	22 Suspected cause of NC: HANDLING <input type="checkbox"/> TRANSPORTATION <input type="checkbox"/> TEST EQUIPMENT <input type="checkbox"/> TOOLS <input type="checkbox"/> SW <input type="checkbox"/> DESIGN <input checked="" type="checkbox"/> OPERATOR/PROCEDURE ERROR <input type="checkbox"/> PART <input type="checkbox"/> MATERIAL <input type="checkbox"/> PROCESS <input type="checkbox"/> TEST <input type="checkbox"/> OTHER..... <input type="checkbox"/>				
	23 Classification: MINOR <input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> Corrective/Preventive Actions: 24				
	25 REQUEST FOR WAIVER YES <input type="checkbox"/> NO <input checked="" type="checkbox"/> N°		26 Analysis Required YES <input type="checkbox"/> NO <input checked="" type="checkbox"/> N°		27 Other related documents:
	Department:	28 P.A.	29 Syst. Engineering	30 P.M.	31 C.C.
	Name:	L. Cremonesi	C. Vettore	M. Olivier	C. Cinquepalmi
	Signature:	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>
Date:	08.09.2009	09.09.2009	09.09.2009	10.09.09	

CUSTOMER/HIGHER LEVEL CONTRACTOR NRB DISPOSITIONS	32 CUSTOMER/HIGHER LEVEL CONTRACTOR NRB Dispositions (Class Major Only):				21 Verifications
	33 Finally determined Cause of NC				34 Corrective/Preventive Actions:
	35 Customer/HLContractor Approval:				36 CLOSE OUT CERTIFICATION
	Department:				CGS PA/QA
Name:					
Signature:					
Date:					



CARLO GAVAZZI SPACE SpA

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AMS02-TCS**NON CONFORMANCE REPORT**

1

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ref

Doc.N° : NCR-TCS-CGS-C-013

Rev.: 1 Date: 08/09/09

Page 2 of 3 attach: 1

37

CONTINUATION SHEET

<input checked="" type="checkbox"/> SUSPECTED CAUSE OF NC	<input type="checkbox"/> INTERNAL NRB DISPOSITION	<input type="checkbox"/> DESCRIPTION OF NC
<input type="checkbox"/> FINALLY DETECTED CAUSE	<input type="checkbox"/> CUSTOMER NRB DISPOSITION	<input type="checkbox"/> CORRECT/PREVENT. ACTIONS
<input type="checkbox"/> REQUIREMENTS VIOLATED		

21 Verifications

TABLE II.2-IIa.- EDGE, CORNER, AND PROTRUSION CRITERIA-
EDGE AND IN-PLANE CORNER RADII*

Application	Radius				Remarks	Figure II.2-5 Referenced
	Outer		Inner			
	in.	mm	in.	mm		
(a) Openings, panels, covers (corner radii in plane of panel)	0.25 0.12	6.4 3.0	0.12 0.06	3.0 1.5	Preferred Minimum	
(b) Exposed corners:	0.50	13.0	—	—	Minimum	(a)
(c) Exposed edges: (1) 0.08 in. (2.0 mm) thick or greater	0.04	1.0	—	—		(b)
(2) 0.02 to 0.08 in. (0.5 to 2.0 mm) thick	Full Radius		—	—		(c)
(3) less than 0.02 in. (0.5 mm) thick	Rolled or Curled					(d)
(d) Flanges, latches, controls, hinges, and other small hardware operated by the pressurized-gloved hand	0.04	1.0	—	—	Minimum required to prevent glove snagging	—
(e) Small protrusions (less than approximately 3/16 in. (4.8 mm)) on toggle switches, circuit breakers, connectors, latches, and other manipulative devices	0.04	1.0	—	—	Absolute minimum unless protruding corner is greater than 120°	

* A 45° chamfer by 0.06 in. (1.5 mm) (minimum) with smooth broken edges is also acceptable in place of a corner radius. The width of chamfer should be selected to approximate the radius corner described above.

AIDC has followed an internal standard (MM-107) which results
EITHER a 45° x 0.3 mm chamfer OR a fillet radius of 0.3 mm for the manufacture
of the main radiators (both RAM and WAKE).



CARLO GAVAZZI SPACE SpA

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AMS02-TCS

NON CONFORMANCE REPORT

1

N
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R
ref

Doc.N° : NCR-TCS-CGS-C-013

Rev.: 1 Date: 08/09/09

Page 3 of 3 attach: 1

37

CONTINUATION SHEET

<input checked="" type="checkbox"/> X	SUSPECTED CAUSE OF NC	<input type="checkbox"/>	INTERNAL NRB DISPOSITION	<input type="checkbox"/>	DESCRIPTION OF NC
<input type="checkbox"/>	FINALLY DETECTED CAUSE	<input type="checkbox"/>	CUSTOMER NRB DISPOSITION	<input type="checkbox"/>	CORRECT/PREVENT. ACTIONS
<input type="checkbox"/>	REQUIREMENTS VIOLATED				

21 Verifications

INTERNAL DISPOSITION

a) White Paint Removal

The paint has to be removed according to the instructions given in NCR-TCS-CGS-C-010 (and here reported in Annex 1) for a distance of 15 mm (maximum) from the edge.

Step 4 of the instructions (to unpolish the surface with a PRIMEX) will not be performed because the involved areas are not going to be repainted.

Verify if in some areas alodine has been removed and if this is the case restore it by brush.

b) Use Acetone to clean the areas with the paint removed and then use Isopropyl alcohol to remove any residue before the tape application

c) Apply the following Silver Teflon tape along the radiator edges :
SHELDAHL G4019 ; CVLY ; TEFLON ; 5.0 MIL ; SILVER / INC ; 966 ,
PERF , 2.5 " ; 108 ' ROLL

According to CGS procedure GD-WI-CGS-017

On the radiative side apply the tape in order to keep a gap not larger than 1mm from the paint .

On the Radiators not painted side take care not to apply the tape on the holes which are present near the edge and on the areas which are treated with Alodine .

Moreover do not cover the holes dedicated to the handles

Objet :

**Stripping of parts
treated with
SG121FD paint.**

CONCERNED PARTS

. Every support.

Diffusion :

(Interne) PDF réseau
APP

(Externe)

Rédaction & approbation :
Responsable Application

Approbation :
Responsable Qualité

PROCESS**➤ After customer approval.**

1) Close up every holes.

2) Remove the SG121FD paint mechanically with the help of a woodstick and a plastic wedge.

Be very carefully with fragile surfaces as kapton, gold treated surface...

3) Clean the stripped surface with the help of a moisten pad with Flugene 113 or Forane 141b.

4) Unpolish the surface with the help of a "PRIMEX" pad ref. NZ089 or equivalent,
to improve the adhesion of future PSI or PSW primer .

5) Clean finally with acetone and Flugene 113 or Forane 141b.

6) Unmask the protected areas.

NOTA :

It is very difficult to strip completely ~~PSI~~ ~~PSX~~ or PSW primers.

Historique des modifications

Description succincte

Création

0

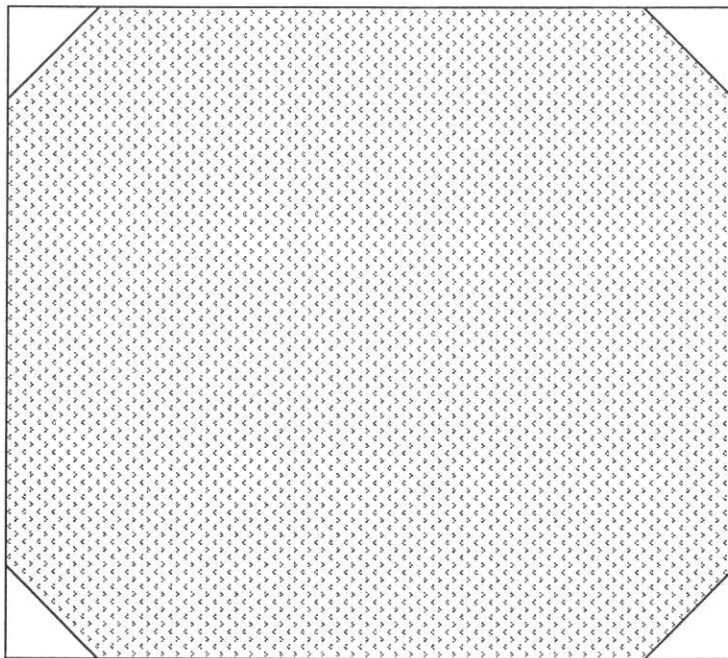
Up to date with PSX Primer in nota part.

1

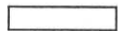
Fin

ANNEXE 1 : P/C/008 – Rév. 2

Epreuve traitée avec PSX + SG121FD ALCATEL ALENIA SPACE



Zone peinte



Zone d'épargne pour bridage dans conteneur